

Work Order ID 165589

Monday, August 28, 2017 11:50:22 AM

165589

Page 1

Item ID: D2654-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 8/24/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/28/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 29 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2654	F								
100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.82							
Skidtubes	1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.08							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.76							
Hand Finishing									

4 0 2017/09/14 AP

4 0 BE 17-09-15

(4) 0 2017-09-19 JSL BEA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.04				4	0	BE 17-09-22	DAS 18 9-20
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: LG002 Memo LOCATION : LG002	0.00 0.04				4		mb66 17/09/22	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40						17/9/25	

DAS
21
9-89

SEP 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

Picklist Print

Monday, August 28, 2017 11:50:25 AM

Page 1

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165589

Parent Item: D2654-3

D2654-3

Parent Item Name: Web

Start Date: 8/24/2017

Required Date: 8/28/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	151.0000	1	4			
D2600-5-108									**				
Extrusion 'I Beam' thin													

Location

Loc Qty

Loc Code

HALL

151

145248

151

4

2017/09/14 (AP)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

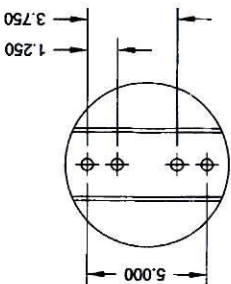
Work Order update only ☐

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1) MAKE D26547-1/-3 FROM D26060-5-108 EXTRUSION, MAKE D26545-5-7 FROM D2607-1-125 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART Q31 005 4.1
3) TOLERANCES: PER DART Q31 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH P/N/D26547-X* PER Q31 044 6.1 (FINE POINT PERMANENT INK MARKER)
7) WEIGHT: D26547-1 = 2.2 lbs; D26547-3 = 2.4 lbs
D26547-5 = 4.8 lbs; D26547-7 = 5.8 lbs

1708-29
165589 MJS
NO. 165589 MJS
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2



18 PL

SEE DETAIL A

Ø0.500

80.8

77.00

67.00

59.28

51.55

43.83

42.58

36.10

28.38

20.00

13.50

8.50

3.50

0.00

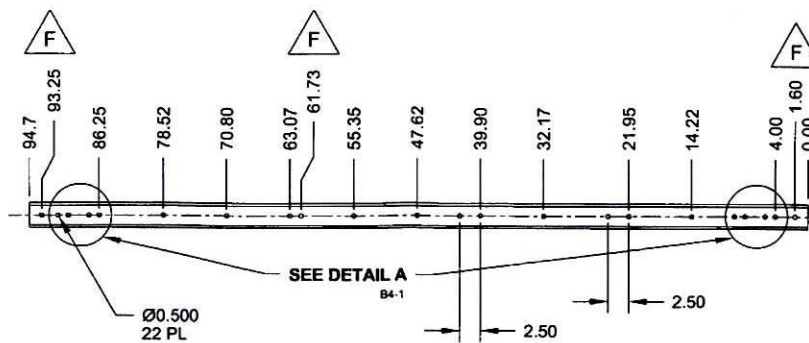
Ø0.63

5.23

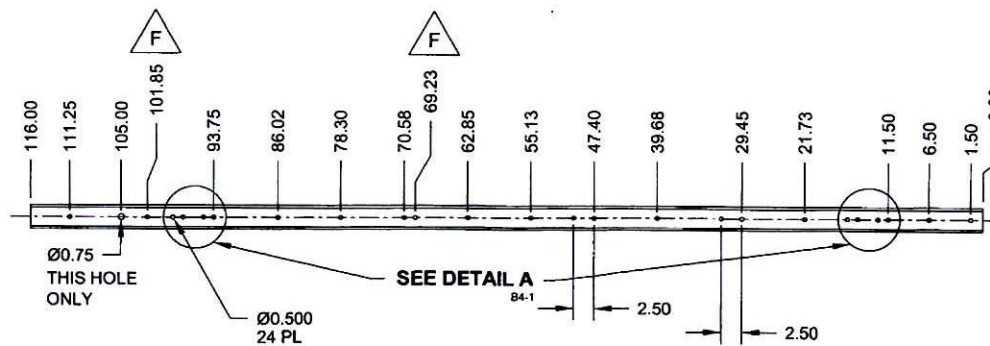
3.98

DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
REV.		WEB	
A	NEW ISSUE	TITLE	
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	D2654	
C	CHANGED HOLE PATTERN	DRAWING NO.	
D	GHW HOLES CHANGED TO 0.63	REV. F	
E	CHANGE LENGTHS, REFORMA	SCALE	
F	INCORPORATED DED D2654-E-2	SHEET 1 OF 2	
	ADDED ADDITIONAL HOLES ON -5.7", 80.8 WAS 80.5.	PORT HADLOCK, WA	
		DART AEROSPACE USA, INC	

RELEASED
2011-09-12



D2654-5 WEB



D2654-7 WEB

RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	